



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4880-041
Job Sheet 166318



Part No: D4880-041

Job Qty: 2 ea

Part Name: 206A/B FWD Leg Assembly, LH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/30/17

Job Tracking No:

Due Date: 10/31/17

Created By: Mario Poulin

Type: Stock

Description:

Customer: Aston Aviation Supplies Pte Ltd (CASTO01)

68 Kallang Pudding Road # 03-03, Syh Logistics Building Singapore, 349327 Singapore

Note: DWG REV C SHEETS 1,2 IPP REV:A 13.12.17 NEW ISSUE DD VERF:JLM IPP REV:B 14.07.07 AS PER DWG REV.C DD VERF:JLM

Ship Via:

Bill of Materials

Part/Part Name	Part Note	Serial No	Quantity	Location
D4880-041 206A/B FWD Leg Assembly, LH	DWG REV C SHEETS 1,2 IPP REV:A 13.12.17 NEW ISSUE DD VERF:JLM IPP REV:B 14.07.07 AS PER DWG REV.C DD VERF:JLM		0.000	
D4880-1 Strut	DWG REV C SHEET 5 IPP REV:A 13.12.17 NEW ISSUE DD VERF:JLM		0.000	
D4883-7 End Fitting	DWG REV C SHEET 4 IPP REV A RQ VERIFIED BY DD		0.000	
D4884-1 End Fitting, Eye	DWG REV A SHEET 1 IPP REV:A NEW ISSUE 14-01-13 JLM VERIFIED BY:DD IPP REV:B DOING PART IN HOUSE FROM NOW ON. RQ 16.11.02 VERIFIED BY: JLM		0.000	
HL32PB5-12 Hi-Lok Pin			0.000	
HL86-5 Hi-Lok Collar	DWG REV PA3		0.000	

Job Routing

Op No	Operation	Qty	Due Date	Standard		Workcenter/Supplier	
				Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	2 Ea	10/30/17	0.00	0.00	Start up container	
110	Small Fab	2 pcs	10/30/17	0.00	1.10	Small Fab	
120	QC	2 pcs	10/30/17	0.00	0.00	QC5	
130	Small Fab	2 pcs	10/31/17	0.00	1.10	Small Fab	
140	QC	2 pcs	10/31/17	0.00	0.00	QC5	
150	Outsource	2 pcs	10/31/17	0.00	0.00	Outsource9	
160	Packaging	2 pcs	10/31/17	0.00	0.00	Packaging2	
170	QC	2 pcs	10/31/17	0.00	0.00	QC5	
180	Packaging	2 pcs	10/31/17	0.00	0.00	Packaging3	
190	QC21-SA	2 Ea	10/31/17	0.00	0.00	QC21	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D4880-1 123 - 0006AN	12	0	0	0
	D4883-7 124	02	0	0	0
	D4884-1 124	2	0	0	0
	HL32PB5-12 562	8	0	0	0

DART
AEROSPACE
S011116

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



206A/B FWD Leg Assembly, LH

PART NO: D4880-041
Revision:
Operation: Start up Operation
Change No:

Mfg Date: 11/18/17
166318

Mfg Date: 11/28/17
Job No: 166318

PART NO: D4880-041
Revision:
Operation:
Change No:
Packaging



DART
AEROSPACE
S014783

206A/B FWD Leg Assembly, LH

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

HL86-5 562
FM129022

8

0

0

0

Part Specifications

Specifications could not be found.

Plex 10/2/17 1:06 PM Dart.lajeunesse.marie

Work Order ID 166318

Friday, September 15, 2017 9:11:38 AM

166318

Page 1

Item ID: D4880-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: 206A/B FWD Leg Assembly, LH
Start Date: 9/15/2017 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 9/25/2017 Req'd Qty: 2.00 ***2*** Customer:
Reference: S/O 132346

Approvals: Process Plan: WM Date: SEP 15 2017 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4880	C

110

0.00

110

1.62

Small Fab

Memo

ALIGN PILOT HOLES IN D4880-1 WITH PILOT HOLES IN D4883-7 AND D4884-1. DRILL OUT EACH HOLES USING A PILOTED DRILL AS PER DWG.
REAM EACH HOLES USING REAMER, USING DART TOOL SETUP DT9971 AS PER DWG.

Small Fab

120

QC5- Inspect part completeness to step on W/O

0.00

120

0.04

QC

Memo

Quality Control

2 ϕ Small
12/11/18

Work Order ID 166318***166318***

Page 2

Friday, September 15, 2017 9:11:38 AM

Item ID: D4880-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: 206A/B FWD Leg Assembly, LH
Start Date: 9/15/2017 Start Qty: 2.00 *?
Required Date: 9/25/2017 Req'd Qty: 2.00 *?
Reference: Cust Item ID:
Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00

130

Small Fab

Memo

1.23

Small Fab

INSTALL PIN/COLLAR AND END FITTING WITH HYSOL WHILE STILL
WET AS PER DWG USE DT9971
A/R HYSOL BATCH: _____

Magnabond M137712

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.04

Quality Control

150

Outsource process - Laser Marking

0.00

150

Outsource9

Memo

0.00

Outsource process - Laser Marking

ISSUE P/O : _____
OUTSOURCE VENDOR: P&L PRINTING
ENGRAVE P# AS PER DWG

C OF C IS REQUIRED

Friday, September 15, 2017 9:11:38 AM

Page 3

NR2

[illegible]

Work Order ID 166318

Friday, September 15, 2017 9:11:38 AM

166318

Page 4

Item ID: D4880-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: 206A/B FWD Leg Assembly, LH
Start Date: 9/15/2017 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 9/25/2017 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

190	QC21- Final Inspection - Work Order Release	0.00							
-----	---	------	--	--	--	--	--	--	--

190

QC

Memo

0.20

Quality Control

Picklist Print

Friday, September 15, 2017 9:11:37 AM

Page 1

Work Order ID: 166318

166318

Parent Item: D4880-041

D4880-041

Parent Item Name: 206A/B FWD Leg Assembly, LH

Start Date: 9/15/2017

Required Date: 9/25/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 13.12.17 NEW ISSUE DD VERF:JLM
14.07.07 AS PER DWG REV.C DD VERF:JLM

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
HL32PB5-12		Purchased	No			110	Each	39.0000	4	8			

HI 32PB5-12

Hi-Lok Pin

Location	Loc Qty	Loc Code
ST562	39	
m137222	1	
m137687	18	
m138116	20	

D4880-1

Manufactured No

110 Each 5.0000 1 2

D4880-1

Strut

Location	Loc Qty	Loc Code
ST123	5	
153891	1	
158185	4	

D4883-7

Manufactured No

110 Each 5.0000 1 2

D4883-7

End Fitting

Location	Loc Qty	Loc Code
ST124	5	
124010	5	

D4884-1

Manufactured No

110 Each 4.0000 1 2

D4884-1

End Fitting, Eye

Location	Loc Qty	Loc Code
ST124	4	
159253	4	

Picklist Print

Friday, September 15, 2017 9:11:38 AM

Page 2

Work Order ID: 166318

166318

Parent Item: D4880-041

D4880-041

Parent Item Name: 206A/B FWD Leg Assembly, LH

Start Date: 9/15/2017

Required Date: 9/25/2017

Start Qty: 2.00

Required Qty: 2.00

HL86-5

Purchased

No

110

Each

162.0000

4

8

HI 86-5

Hi-Lok Collar

Location

Loc Qty

Loc Code

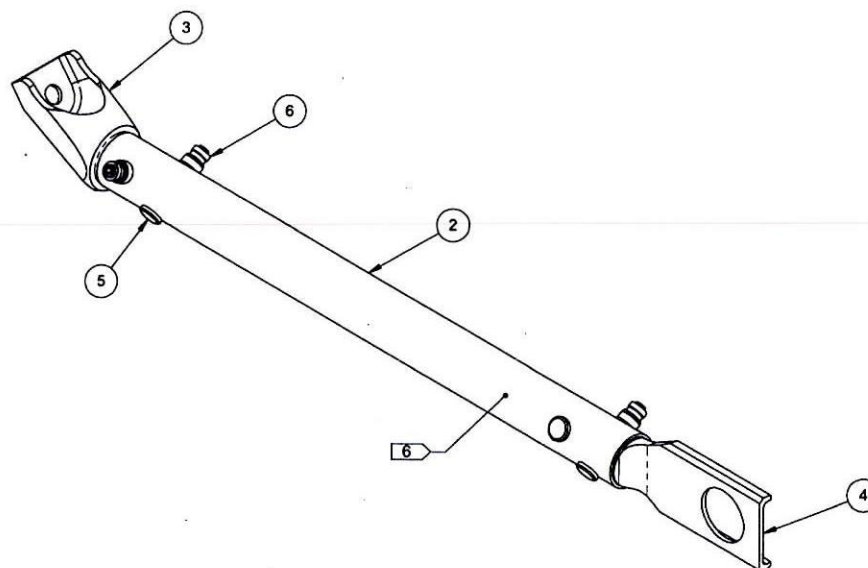
ST562

162

M129022

162

ITEM	QTY. -041	P/N	DESCRIPTION
1	X	D4880-041	FWD LEG ASSEMBLY, LH
2	1	D4880-1	STRUT
3	1	D4883-7	END FITTING
4	1	D4884-1	END FITTING, EYE
5	4	HL32PB5-12	HI-LOK PIN
6	4	HL86-5	HI-LOK COLLAR



D4880-041 FWD LEG ASSEMBLY, LH
(EQUIVALENT TO BELL P/N 206-062-101-101)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.8
- 7) WEIGHT: 0.69 lbs
- 8) ALIGN PILOT HOLES IN D4880-1 WITH PILOT HOLES IN D4883-7 & D4884-1.
DRILL OUT EACH HOLE USING A P/N 13-SB65 (0.125) PILOTED DRILL.
REAM EACH HOLE USING P/N 31-219 (Ø0.1610) REAMER, USING DART TOOL SETUP DT9971
- 9) INSTALL PIN/COLLAR AND END FITTING WITH HYSOL EA934NA OR MAGNOBOND 6398 ADHESIVE WHILE STILL WET
- 10) ASSEMBLE PER DART TOOL DT9971
- 11) INSTALL HL32PB5-12 HI-LOK IN ORIENTATION SHOWN

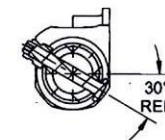
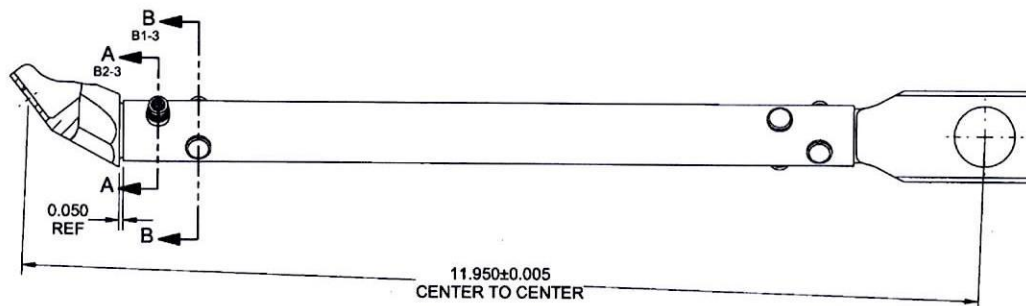
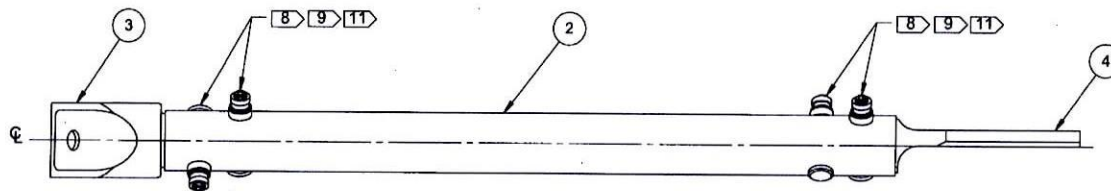
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RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 166318

SEP 15 2017

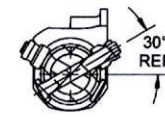
RELEASED
2014-07-03

C	HL32PB5-12 WAS HL20PB5-12 (ZN D4-1, D4-3); REVISE NOTE 6) (ZN A8-5); ADD "FWD" (ZN B4-1, B4-2, B4-3, B4-4)	RF	14.06.24
B	REVISE NOTES 6), 7) & 9) (ZN A8-1, A8-3); ADDED BELL P/N	RF	14.04.08
A	NEW ISSUE	RF	13.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	HS	DRAWING NO.	REV. C
MFG. APPR.	JLM	D4880	SHEET 1 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	LEG ASSEMBLY	NTS
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APPROVED



SECTION A-A C7-3
2 PL, SIMILAR



SECTION B-B C7-3
2 PL

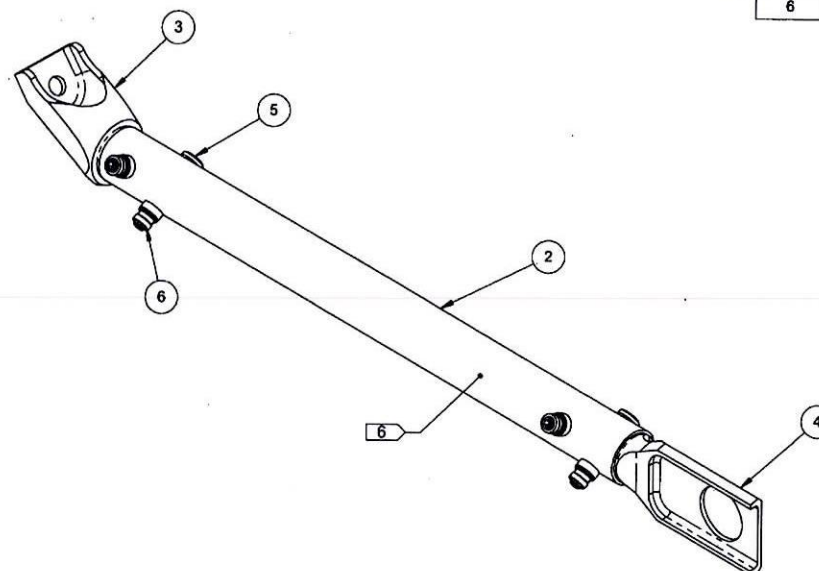
D4880-041 FWD LEG ASSEMBLY, LH
AUXILIARY VIEW

RELEASED
2014-07-07
WJP

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	HS	DRAWING NO.	REV. C
MFG. APPR.	JLM	D4880	SHEET 2 OF 5
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DE APPR.	DS	LEG ASSEMBLY	NTS
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ITEM	QTY. -042	P/N	DESCRIPTION
1	X	D4880-042	FWD LEG ASSEMBLY, RH
2	1	D4880-1	STRUT
3	1	D4883-5	END FITTING
4	1	D4884-1	END FITTING, EYE
5	4	HL32PB5-12	HI-LOK PIN
6	4	HL86-5	HI-LOK COLLAR



D4880-042 FWD LEG ASSEMBLY, RH
(EQUIVALENT TO BELL P/N 206-062-101-102)

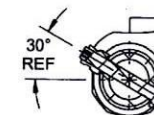
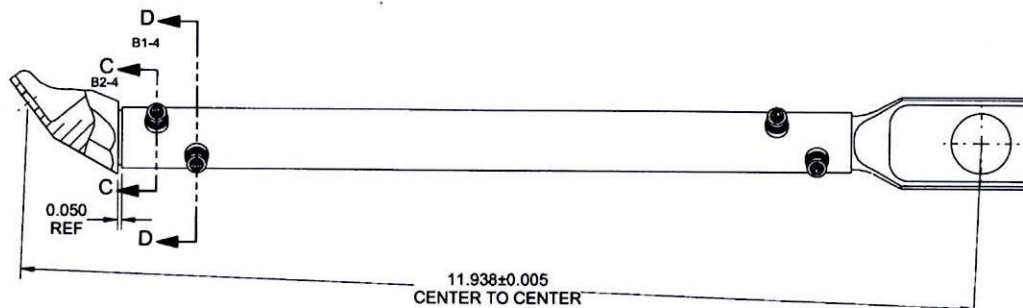
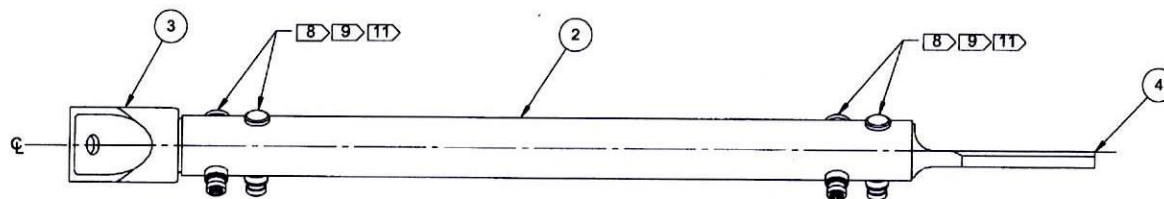
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.8
- 7) WEIGHT: 0.69 lbs
- 8) ALIGN PILOT HOLES IN D4880-1 WITH PILOT HOLES IN D4883-5 & D4884-1.
DRILL OUT EACH HOLE USING A P/N 13-SB65 (0.125) PILOTED DRILL.
REAM EACH HOLE USING P/N 31-219 (Ø0.1610) REAMER, USING DART TOOL SETUP DT9972
- 9) INSTALL PIN/COLLAR AND END FITTING WITH HYSOL EA934NA OR MAGNOBOND 6398 ADHESIVE WHILE STILL WET
- 10) ASSEMBLE PER DART TOOL DT9972
- 11) INSTALL HL32PB5-12 HI-LOK IN ORIENTATION SHOWN

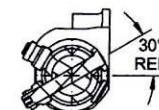
RELEASED
2014-07-07

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	HS	DRAWING NO. D4880	REV. C
MFG. APPR.	JLM	SHEET 3 OF 5	
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	LEG ASSEMBLY	NTS
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SECTION C-C C7-4
2 PL



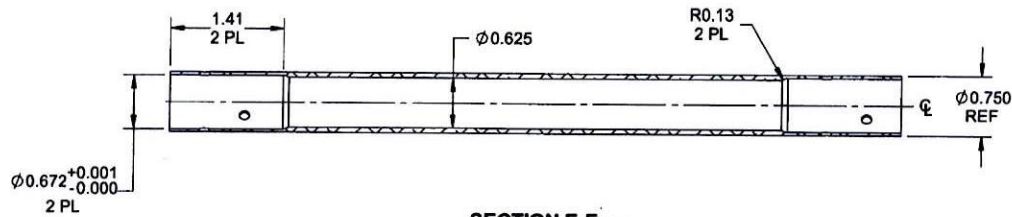
SECTION D-D C7-4
2 PL

D4880-042 FWD LEG ASSEMBLY, RH
AUXILIARY VIEW

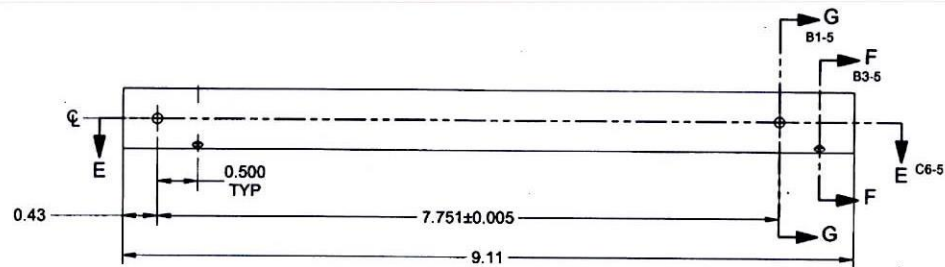
RELEASED
2014-07-07

APPROVED

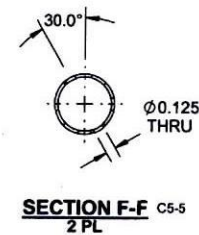
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	HS	DRAWING NO.	REV. C
MFG. APPR.	JLM	D4880	SHEET 4 OF 5
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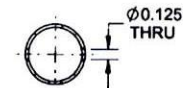
SECTION E-E B4-5



D4880-1 STRUT



SECTION F-F C5-5
2 PL



SECTION G-G C5-5
2 PL

NOTES:

- 1) MATERIAL: 17-4 PH/S17400/TYPE 630 SS ROUND BAR, H900 CONDITION
PER AMS 5643/ASTM A564
DART SPEC M17-4-R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.6
- 7) WEIGHT: 0.31 lbs
- 8) LIQUID PENETRANT INSPECT PER QSI 038 6.1.1 (ASTM E1417 LEVEL 2)

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	HS	DRAWING NO.	REV. C
MFG. APPR.	JLM	D4880	SHEET 5 OF 5
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RELEASED
2014-07-07
WJ



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO038429

Supplier: PLP001-VC
P & L Printing
19226 Airport Road
Summerstown
ON
KOC 2EO Canada
Phone: 613-931-1241

PO No: PO038429
PO Date: 11/21/17
Due Date: 11/24/17
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

E-MAILED
NOV 21 2017

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Part	Rev	Supplier Part No	Item No	Description	Item Tax	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	D4880-041				206A/B FWD Leg Assembly, LH Engrave P/N as per Dwg D4880 Rev C		Firmed	11/24/17	2 pcs	0 pcs	2 pcs	\$4.00/pcs	\$8.00
													Grand Total: \$8.00

Order Notes

DWG REV C SHEETS 1,2 IPP REV:A 13.12.17 NEW ISSUE DD VERF:JLM IPP REV:B 14.07.07 AS PER DWG REV.C DD VERF:JLM

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retension of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 11/21/17 10:15 AM dart.baker.diane



19226 Airport Road
Summerstown, ON
K0C 2E0 Canada

Tel. 613-931-1241
Fax 613-931-2560
plprinting@bellnet.ca

PACKING SLIP

SOLD TO

DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

SHIPPED TO

DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

DATE November 27, 2017

P.O NUMBER PO38429

ITEM DESCRIPTION

D4880-041 LEG ASSEMBLY

QUANTITY

2

COMMENTS

ALL ITEMS HAVE BEEN LASER MARKED

Q 171-28



19226 Airport Road
Summerstown, ON
K0C 2E0

plprinting@bellnet.ca www.plprinting.ca

Tel.: 613 931-1241
Fax: 613 931-2560

Invoice

Number: 9513

Date: November 27, 2017

Bill To:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7

Ship To:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7

PO Number	Terms	Ship Via
38429		

Description	Quantity	Price	HST	Amount
Laser Metal Marking, D4880-041 ✓	2.00	4.00	✓	8.00 ✓
<i>Spent 11-28</i>				
Sub-Total				\$8.00
HST 13.00% on 8.00				1.04
Total				\$9.04

We do more than just print on paper!

*Whatever we make, we make it the best we possibly can.
We make it as good as if we were going to keep it for ourselves.*

H.S.T. No. 13301 4258

2% INTEREST CHARGED ON OVERDUE ACCOUNTS
PAY BY INVOICE NO STATEMENT WILL BE ISSUED

Thank You